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POSITIVE RECALL

EFFECTIVE 19/7/29 AUTH 4

RELEASED 18 DATE 19.12.04

Req. Eng
test fit.

D2893-1

Job Sheet 197734



Part No: D2893-1

Job Qty: 10 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/16/19

Job Tracking No:

Due Date: 8/9/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs	8/9/19		0.33	19.61	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	10 pcs	8/9/19		0.00	0.00	QC 8 - 12		M.M. 2019/07/30
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Crosstubes - 2 - B4B	10 pcs	8/9/19		0.00	1.67	Crosstubes - 1 - B4B		

140 QC 3	10 pcs	8/9/19	0.00	0.00	Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	AS 19-8-11
					QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	DAS 81
					QC 3 - 24	9-89
					QC 3 - 61	
					QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	10 pcs	8/9/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	DAS 41 DEC 05 2019
					Packaging 3 - 23 - B4B	9-89
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	



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9-89

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	8/9/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	DEC 06 2019

Part Op **100** - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. *5176225 exp 6/20*
140 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____) LOCATION: LG050
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	5 pcs (.5 ea)	100-HAAS 4 Axis	<i>5170125(1)</i>
				<i>5180404(2) 5167085(3)</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	5	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

DART AEROSPACE LTD		Work Order: 197734
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		3.000	2.999	2.998	2.999	3.000
AB	0.440	0.460		.455	.455	.455	.456	.455
AC	0.125	0.160		.137	.138	.139	.139	.139
AD	0.040	0.060		.049	.049	.050	.049	.050
AE	0.188	0.193		.188 Ø	.188 Ø	.188 Ø	.188 Ø	.188 Ø
AF	0.125	0.160		.138	.138	.137	.139	.138
AG	0.140	0.160		.154	.154	.153	.152	.156
AH	1.360	1.400		1.377	1.378	1.376	1.376	1.376
AI	0.040	0.060		.049	.049	.049	.049	.048
AJ	1.190	1.230		1.216	1.218	1.218	1.217	1.214
AK	0.010	0.020		.015	.015	.010	.010	.012
AL	0.053	0.073		R.063 Ø	R.063 Ø	R.063 Ø	R.063 Ø	R.063 Ø
AM	0.240	0.260		R.250 Ø	R.250 Ø	R.250 Ø	R.250 Ø	R.250 Ø
AN	2.518	2.538		2.536	2.537	2.538	2.538	2.538
AO	84.39	90.39		87.00	87.00	87.00	87.00	87.00
AP	0.261	0.266		.261 Ø	.261 Ø	.261 Ø	.261 Ø	.261 Ø
AQ	0.053	0.073		R.063 Ø	R.063 Ø	R.063 Ø	R.063 Ø	R.063 Ø
AR								
AS								
AT								
Accept/Reject								

Measured by: ML

Date: 20/4/07/30

Audited by: gmm

Date: 19/05/11

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

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DART AEROSPACE LTD		Work Order:	197734
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
HAAS Section								
AA	2.985	3.005		2.999	2.999	3.000	2.998	2.999
AB	0.440	0.460		.455	.455	.457	.455	.455
AC	0.125	0.160		.138	.139	.139	.141	.141
AD	0.040	0.060		.049	.050	.050	.049	.049
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.139	.139	.139	.138	.138
AG	0.140	0.160		.155	.156	.154	.153	.152
AH	1.360	1.400		1.375	1.375	1.377	1.375	1.375
AI	0.040	0.060		.051	.051	.050	.048	.049
AJ	1.190	1.230		1.217	1.215	1.216	1.213	1.212
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		R.063 ok	R.062 ok	R.063 ok	R.063 ok	R.063 ok
AM	0.240	0.260		R.250 ok	R.250 ok	R.250 ok	R.250 ok	R.250 ok
AN	2.518	2.538		2.537	2.537	2.536	2.535	2.536
AO	84.39	90.39		87.00	87.00	87.00	87.00	87.00
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		R.063 ok	R.062 ok	R.063 ok	R.063 ok	R.063 ok
AR								
AS								
AT								
Accept/Reject								

Measured by:	M.M.	DAS 64 9-89	Date:	2019/07/31
Audited by:			Date:	19/08/11
Preliminary Approval:			Date:	

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		Page 1 of 1	

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HAAS Section								
AA	2.985	3.005		2.994	3.000			
AB	0.440	0.460		.455	.457			
AC	0.125	0.160		.139	.140			
AD	0.040	0.060		.050	.050			
AE	0.188	0.193		.188p	.188p			
AF	0.125	0.160		.140	.140			
AG	0.140	0.160		.152	.152			
AH	1.360	1.400		1.376	1.375			
AI	0.040	0.060		.049	.049			
AJ	1.190	1.230		1.214	1.213			
AK	0.010	0.020		.012	.012			
AL	0.053	0.073		R.063 OK	R.063 OK			
AM	0.240	0.260		R.250 OK	R.250 OK			
AN	2.518	2.538		2.537	2.536			
AO	84.39	90.39		87.00	87.00			
AP	0.261	0.266		.261p	.261p			
AQ	0.053	0.073		R.063 OK	R.063 OK			
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>mm</i>	DAS	Date:	<i>2019/07/31</i>
Audited by:	<i>gmc</i>	64	Date:	<i>19/08/11</i>
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	<i>[Signature]</i>

